

machine. The bottom of rack *D* has a narrow slot *V* cut in it extending from *F* to *G*.

A hardened stop-pin *E* is driven tightly into base *J5* which protrudes into slot *V* as shown, thus determining the length of movement of rack *D* in each direction. A safety latch *H* is fastened to bracket *C*, swinging about screw *J* and resting with its tapered nose upon the taper end *T* of the low offset

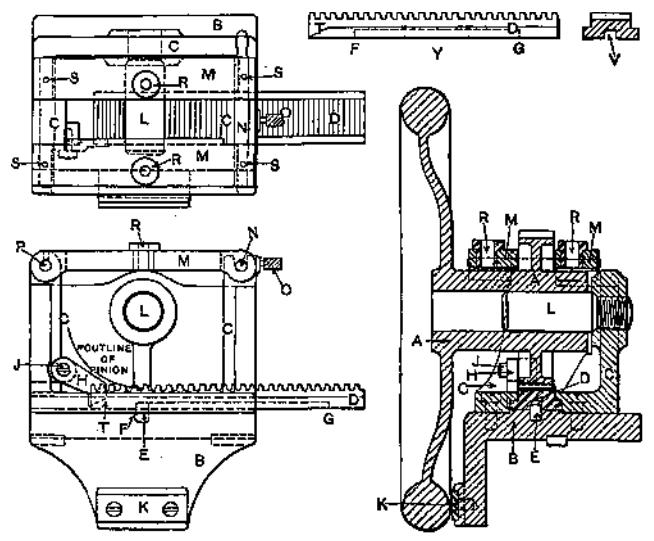


Fig. 2. Jig for Drilling Set-screw Holes in Work shown in Fig. 1

portion of rack *D*. Latch *H* is held in constant contact with *D* by its own weight.

To use the jig drill guides *M*, bushings *R* are swung out and the wheel is slipped upon pin *L* until the finished rim of *A* comes against the finished steel supporting plate *K*. If the operator should fail to push the wheel far enough, it will be impossible to close the drill guides *M*, as the slot

between the guides that fits over the pinion will only pass over it when the wheel is in the proper place. Thus the correct location of the holes is assured. The guides are closed and the first two holes drilled and tapped. A quick-acting chuck is used to